



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-241
Job Sheet 178857



Part No: D119-796-241

Job Qty: 1 ea

Part Name: Aft Crosstube Installation Without Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/8/18

Job Tracking No:

Due Date: 6/22/18

Created By: Jesse White

Type: Stock

Description:

Note: D119-796-241 REV.J IPP REV:A 14.09.03 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.B
DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.12 AS PER REV.pd1 DD
VERF:JLM IPP REV:E 15.02.11 AS PER REV F JLM VERIFIED BY:DD IPP REV:F 17.05.08 AS PER IIN
REV.F DD VERF:JFS

Ship Via:

Bill of Materials

TRN 5078278



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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Container No: S079531



Part: D119-796-241

Job No: 178857

Serial No/Batch: S079531

Revision: J

Inspector:

Exp Date:

Instructions:

Date: 06/11/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Crosstubes-1		GP 18-06-11
120	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging1-1		GP 18-06-11
130	CNC Bend Crosstubes	1 pcs	6/22/18	6/22/18	4.67	4.17	CNC Bend Crosstube		GP 18-06-11
140	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC15		GP 18-06-12
145	Crosstubes	1 pcs	6/22/18	6/22/18	0.00	3.30	Crosstubes-1		GP 18-06-12
150	Crosstubes	1 pcs	6/22/18	6/22/18	0.00	3.30	Crosstubes-1		GP 18-06-13
160	HandFXtube	1 pcs	6/22/18	6/22/18	0.00	1.28	HandFinish5		GP 18-06-13
170	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC7-1		GP 18-06-13
175	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5		GP 18-06-13
180	Outsource	1 pcs	6/22/18	6/22/18			SKY002-VC	2	
190	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging2	DAS	JUL 05 2018
200	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5	6	38
230	SprayPaint	1 pcs	6/22/18	6/22/18	0.00	1.31	Spray Paint	9-89	AS 18-06-13 0 2018
240	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC14		38
242	Crosstubes	1 pcs	6/22/18	6/22/18	0.00	3.30	Crosstubes-1		AS 18-06-13 0 2018
244	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
246	SprayPaint	1 pcs	6/22/18	6/22/18	0.00	1.31	Spray Paint		AS 18-06-13 0 2018
248	SprayPaint	1 pcs	6/22/18	6/22/18	0.00	1.31	Spray Paint		AS 18-06-13 0 2018
250	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC14		38
252	Crosstubes	1 pcs	6/22/18	6/22/18	0.00	3.30	Crosstubes-1		AS 18-06-13 0 2018
260	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
270	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging1-1		AS 18-06-13 0 2018
280	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC4		JUL 09 2018
290	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1	LG050	AS 18-06-13 0 2018
295	DC	1 pcs	6/22/18	6/22/18	0.00	0.00	DC		NR 18-06-13
300	QC21-FG	1 Ea	6/22/18	6/22/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 130 - Bend tube as per Dwg D119-796-241 using CNC bender program

Descriptions: 145 - 1- CUT TUBE AT HEIGHT ON FAI SHEET

150 - ***** ENSURE PROPER JIG POSITIONING *****

160 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D119-796-241

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O Primer 138847

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

242 - Assemble as per dwg D119-796-241 and QSI 2- Install D5152-043 with proseal 890 on concave surface, 0.100" MIN thick as per dwg using DT10112 (identified right and left) 3- Install center support without bonbing. 4- Install Damper support and contact pads using proseal 890 per dwg and clamp in position. 138848 exp 11/18

244 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

246 - ***VERIFY BY _____ BATCH # TO MATCH W/O Primer 138847 Clear 138832248 - ***VERIFY BY _____ BATCH # TO MATCH W/O Paint 138875

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

252 - 1- Re-install non fixed hardware per dwg ***Torque clamps on damper and contact pad to 80-100 IN-LBS.*** 2- Proseal 138848 exp 11/18Apply a filet-seal of proseal 890 around damper supports and contact pads. SikaFlex 138875 exp 12/18

260 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED AS PER DWG.*** 1- ATTACH A RED TAG TO CENTER SUPPORT THAT READS CENTER SUPPORT NOT FIXED THEN DATE AND STAMP IT.

290 - Identify and pack for shipping as per PPP D119-796-241

295 - Photocopy bluefile and create labels as per PPP D119-796-241 chg 005

on w/o 176934

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
CR3212-4-07	Cherry Rivet	16 Ea (16 ea)	242-Crosstubes	
D2873-043	Nut Plate Assembly	4 Ea (4 ea)	242-Crosstubes	
D5122-1	Center Support, Upper	1 Ea (1 ea)	252-Crosstubes	
D5123-1	Clamp Cushion	6 Ea (6 ea)	252-Crosstubes	
D5123-5	Clamp Cushion	2 Ea (2 ea)	252-Crosstubes	
D5134-041	Damper Support Assembly, LH	1 Ea (1 ea)	252-Crosstubes	
D5134-042	Damper Support Assembly, RH	1 Ea (1 ea)	252-Crosstubes	
D5136-1	Contact Pad, LH	1 Ea (1 ea)	252-Crosstubes	
D5136-2	Contact Pad, RH	1 Ea (1 ea)	252-Crosstubes	
D5152-043	Aft Post Mount Assembly	2 Ea (2 ea)	252-Crosstubes	
MS21920-25	Clamp	6 Ea (6 ea)	252-Crosstubes	
MS21920-28	Clamp	2 Ea (2 ea)	252-Crosstubes	
D5515-1	Grounding Clamp	2 Ea (2 ea)	252-Crosstubes	
MS21042L3	Nut	2 Ea (2 ea)	252-Crosstubes	
MS27039-1-08	Screw	2 Ea (2 ea)	252-Crosstubes	
NAS1149D0332J	Washer	4 Ea (4 ea)	252-Crosstubes	
AN174-3A	Bolt	2 Ea (2 ea)	270-Packaging	
MS21042L4	Nut	2 Ea (2 ea)	270-Packaging	
NAS1149D0432J	Washer	4 Ea (4 ea)	270-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241TRN	1	6	0
242-Crosstubes	CR3212-4-07 M138333-10	16	324	0
	D2873-043 5050177	4	19	0
252-Crosstubes	D5122-1 F165637	1	3	0
	D5123-1 F153232	6	223	0
	D5123-5 F153235	2	204	0
	D5134-041 5000856	1	2	0
	D5134-042 5079364	1	0	0
	D5136-1 5082473	1	12	0
	D5136-2 5063066	1	12	0
	D5152-043 5064536	2	10	0
	D5515-1 5053280	2	30	0
	-MS21042L3 5078167	2	1,902	0
	MS21920-25 5066660	6	140	0
	-MS21920-28 5060057	2	48	0
	-MS27039-1-08 5020602	2	386	0
	-NAS1149D0332J 5035396	4	1,829	0
270-Packaging	AN174-3A 5002774	2	50	0
	MS21042L4 5062378	2	2,965	0
	NAS1149D0432J FM137459-15	4	214	0

DAS
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5-88

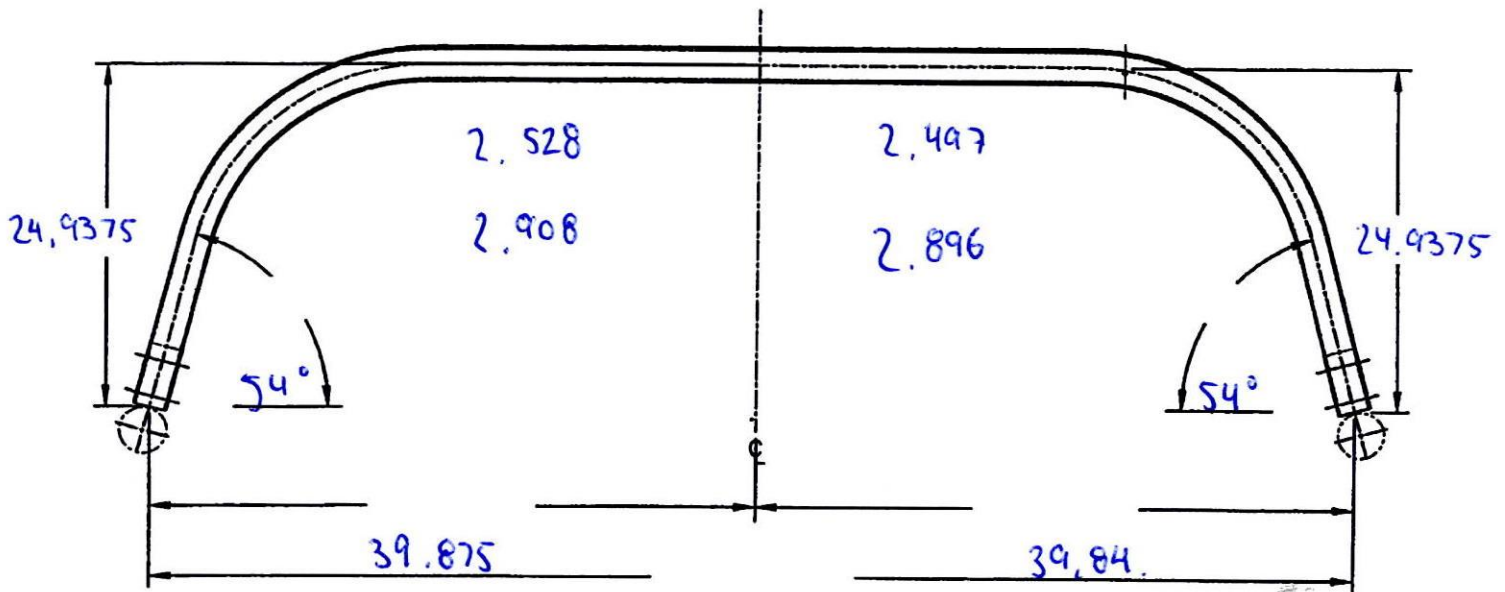
JUL 09 2018

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
2	Crosstube Assembly (AW119 MKII Aft)	2.516Inches + 0.005 - 0.000	2.521 2.516		
3	Crosstube Assembly (AW119 MKII Aft)	2.626Inches + 0.005 - 0.000	2.631 2.626		
4	Crosstube Assembly (AW119 MKII Aft)	2.627Inches + 0.005 - 0.000	2.632 2.627		
5	Crosstube Assembly (AW119 MKII Aft)	2.798Inches + 0.005 - 0.000	2.803 2.798		
6	Crosstube Assembly (AW119 MKII Aft)	2.799Inches + 0.005 - 0.000	2.804 2.799		
7	Crosstube Assembly (AW119 MKII Aft)	2.989Inches + 0.005 - 0.000	2.994 2.989		
8	Crosstube Assembly (AW119 MKII Aft)	3.191Inches + 0.005 - 0.000	3.196 3.191		
9	Crosstube Assembly (AW119 MKII Aft)	3.200Inches + 0.005 - 0.000	3.205 3.200		
10	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
11	Crosstube Assembly (AW119 MKII Aft)	2.516Inches + 0.005 - 0.000	2.521 2.516		
12	Crosstube Assembly (AW119 MKII Aft)	2.626Inches + 0.005 - 0.000	2.631 2.626		
13	Crosstube Assembly (AW119 MKII Aft)	2.627Inches + 0.005 - 0.000	2.632 2.627		
14	Crosstube Assembly (AW119 MKII Aft)	2.798Inches + 0.005 - 0.000	2.803 2.798		
15	Crosstube Assembly (AW119 MKII Aft)	2.799Inches + 0.005 - 0.000	2.804 2.799		
16	Crosstube Assembly (AW119 MKII Aft)	2.989Inches + 0.005 - 0.000	2.994 2.989		
17	Crosstube Assembly (AW119 MKII Aft)	3.191Inches + 0.005 - 0.000	3.196 3.191		
18	Crosstube Assembly (AW119 MKII Aft)	3.200Inches + 0.005 - 0.000	3.205 3.200		
19	Crosstube Assembly (AW119 MKII Aft)	105.710Inches ± 0.020	105.730 105.690		

Plex 6/8/18 10:59 AM dart.white.jesse

DART AEROSPACE LTD		Work Order:	
Description: Crosstube Aft, with Step		Part Number:	D119-796-241
Inspection Dwg: D119-796-241 Rev: J			Page 1 of 1

Required Dimension	Min	Max
Height	24.840	25.100
1/2 Span	39.810	40.070
Angle	54°	57°
Total Span	79.620	80.140
Bending Passes	8	--
Crushing	--	8.5%

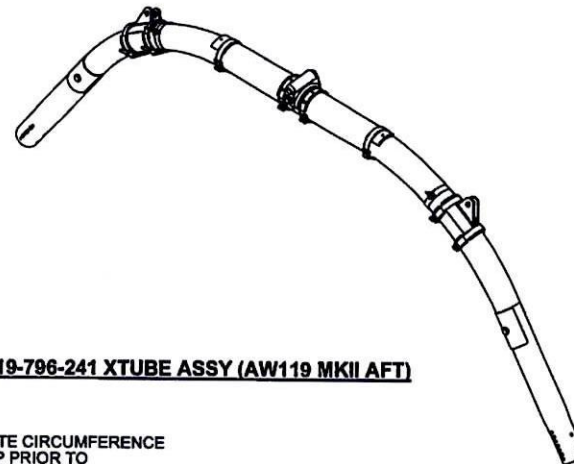


	Side A	Side B
Bending Passes	11	12
Crushing	7.0%	7.4%
Comments		

QC15 Inspection	EB
Date	18-06-12

Rev	Date	Change	Revised by	Approved
A	15.04.14	New Issue	KJ	
B	15.11.12	Min angle revised	KJ	
C	15.12.15	Dwg Rev updated	KJ	
D	17.07.12	Dwg Rev updated	KJ	

D119-796-241 XTUBE ASSY (AW119 MKII AFT)



NOTES:

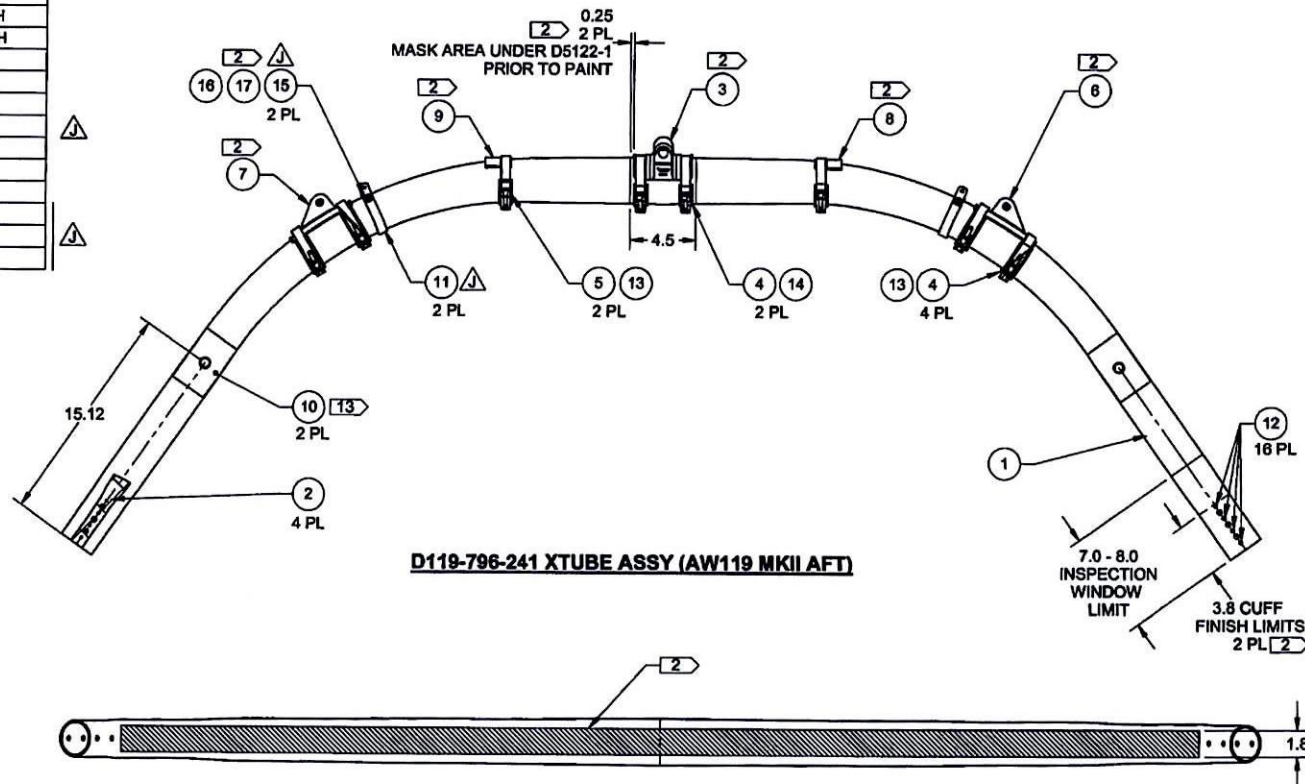
- 1) MATERIAL: N/A
- 2) FINISH: MASK D5134-041/-042 DAMPER SUPPORT ASSEMBLIES, CUFFS, D5136-1/-2 CONTACT PADS, THE COMPLETE CIRCUMFERENCE OF THE TUBE UNDER THE D5122-1 CENTER SUPPORT AND THE TAB ON THE D5515-1 GROUNDING CLAMP PRIOR TO APPLICATION OF CLEAR COAT/PAINT.
IF NECESSARY TOUCH UP PRIMER ON OUTSIDE OF CROSSTUBE PER DART QSI 005 4.2.
APPLY MATTE CLEAR COAT TO THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA) PER QSI 005 4.2.
MASK THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA).
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-241" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 28.26 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL D5122-1 CENTER SUPPORT HAND TIGHT ONLY. DO NOT TORQUE. INSTALL RED TAG TO INDICATE "D5122-1 CENTER SUPPORT MUST BE BONDED PER IIN-D119-796 PRIOR TO FLIGHT".
- 10) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5136-1/-2 AND SURFACE OF CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5136-1/-2 CONTACT PADS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL MS21920-25 CLAMPS AND D5123-5 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY. THE NUT HAS NOT BOTTOMED-OUT AFTER TORQUING AND THE NUT IS FACING AFT.
- 12) PRIOR TO FINISHING, POSITION AND INSTALL D5134-041/-042 DAMPER SUPPORTS USING JIG DT10085. ABRASE MATING SURFACES OF THE D5134-041/-042 DAMPER SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5134-041/-042. INSTALL MS21920-25 CLAMPS AND D5123-1 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS. ENSURE THAT THE MS21920 CLAMPS ARE POSITIONED AS SHOWN IN DETAIL C.
- 13) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-043 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. INSTALL D5152-043 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.100" MIN THK LOCATE D5152-043 USING TOOL DT10112.
- 14) INSTALL THE D5515-1 GROUNDING CLAMP AND ASSOCIATED HARDWARE PER DETAIL "C" PRIOR TO FINISHING. TORQUE THE MS21042-3 NUT 12-15 IN-LB. COMPLETELY SEAL THE EDGES OF THE CLAMP USING PROSEAL 890.
- 15) CARRY OUT A RESISTANCE CHECK BETWEEN THE D5515-1 GROUNDING CLAMP AND ANY UNPAINTED SECTION OF THE CROSSTUBE IN ACCORDANCE WITH AC43-13-1B CHAPTER 11. MAXIMUM RESISTANCE IS 3 MEGOHMS.

J	ADD NOTE 14 & 15 ON SHT 1, ADD PAINT/PRIMER MASKING LOCATIONS, REVISE NOTES ON SHT 1 & 4, REVISE BOM ON SHT 2 TO ADD GROUNDING CLAMP AND ASSOCIATED HARDWARE. REF PAR 17-580	ML	17.02.10
I	D6023-106 MATERIAL REPLACES D6008-106, D5136-1/-2 & D5134-041/-042 NOW INSTALLED ON PRIMER	AP	15.10.13
H	NOTE 9 RE-WRITTEN, BONDING INSTRUCTIONS MOVED TO IIN. SEE PREVIOUS REV FOR DETAILS.	AP	15.07.02
G	FINISHING ORDER ADJUSTED, UPDATE BEND TOLERANCE AND TRN DETAIL TOLERANCE TO MATCH D119-796-141 DWG	AP	15.04.24
F	REMOVED PRIMER/PAINT ON CUFFS, 2.516 WAS 2.500 (C8-5)	AP	15.02.03
E	D5152-043 WAS D5150-3, SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER	DB	15.01.15
D	ADD D5150-3 STEP POST (2X), MOVED INSPECTION WINDOW DETAIL TO SHT 1, MODIFIED NOTES ON SH 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WAS CR3212-4-05 RIVETS, RADIUS BLOCK WAS NUT PLATE ASSEMBLY (BOM), REMOVED 7.5 DEG CUFF HOLE OFFSET (A1-3), REDUCED CUFF DIA TO 2.500 (C8-5), ADD INSPECTION WINDOW	AP	14.10.23
B	ORIENTATION OF D5122-1 CENTER SUPPORT WAS CORRECTED. D5123-5 ADDED UNDER D5136-1/-2 CONTACT PADS, ADDED D2873-043 NUT PLATE ASSY & CR3212-4-05 RIVETS, ADDED REFERENCE TO SKIDTUBES FOR LOCATING CUFF HOLES, RE-ORGANIZED NOTES, REMOVED REDUNDANT INFORMATION.	AP	14.09.08
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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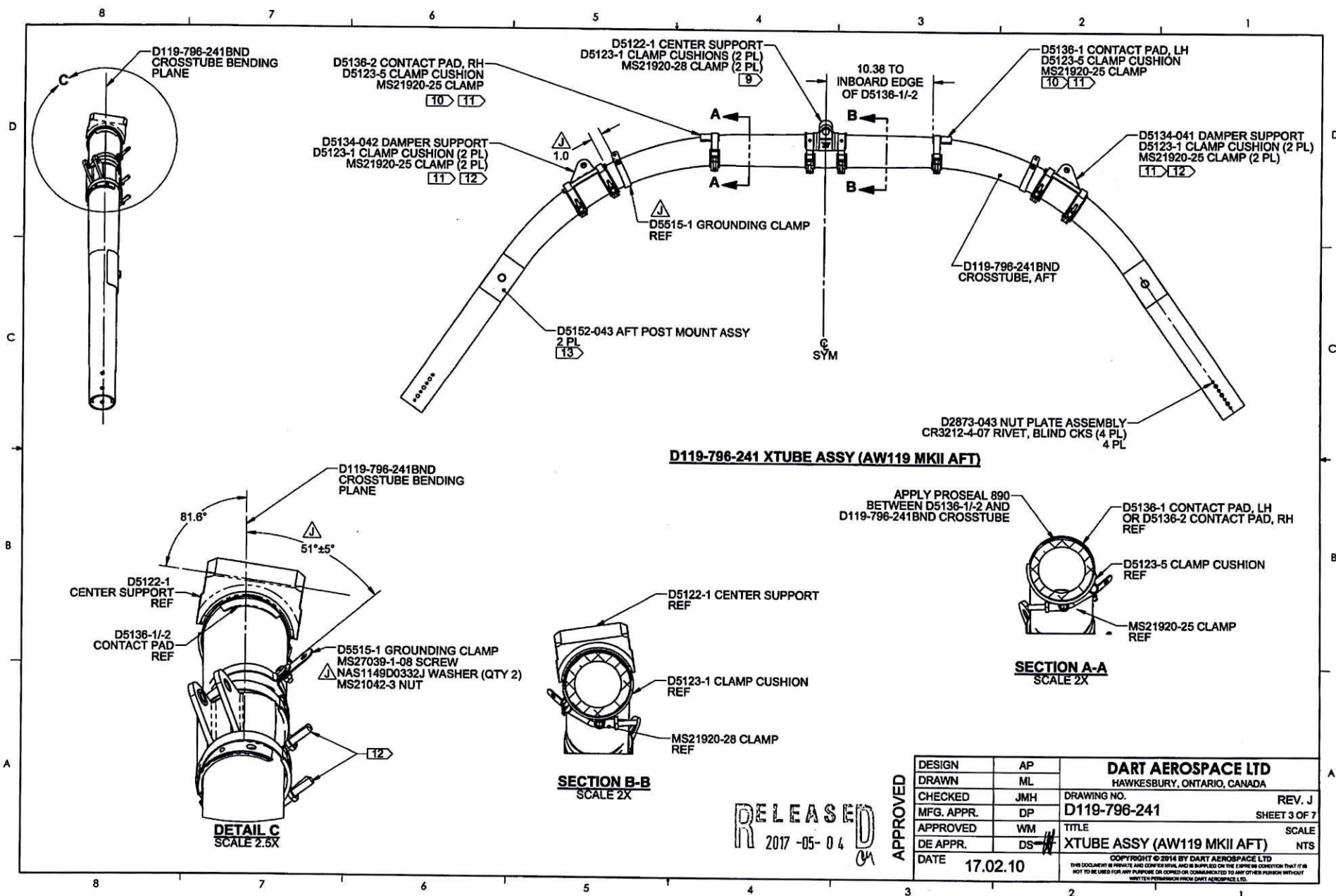
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241BND	CROSSTUBE, AFT
2	4	D2873-043	RADIUS BLOCK
3	1	D5122-1	CENTER SUPPORT
4	6	D5123-1	CLAMP CUSHION
5	2	D5123-5	CLAMP CUSHION
6	1	D5134-041	DAMPER SUPPORT ASSY, LH
7	1	D5134-042	DAMPER SUPPORT ASSY, RH
8	1	D5136-1	CONTACT PAD, LH
9	1	D5136-2	CONTACT PAD, RH
10	2	D5152-043	AFT POST MOUNT ASSY
11	2	D5515-1	GROUNDING CLAMP
12	16	CR3212-4-07	CSK RIVET, CHERRY MAX
13	6	MS21920-25	CLAMP
14	2	MS21920-28	CLAMP
15	2	MS27039-1-08	SCREW, PAN-HEAD
16	2	MS21042-3	NUT
17	4	NAS1149D0332J	WASHER



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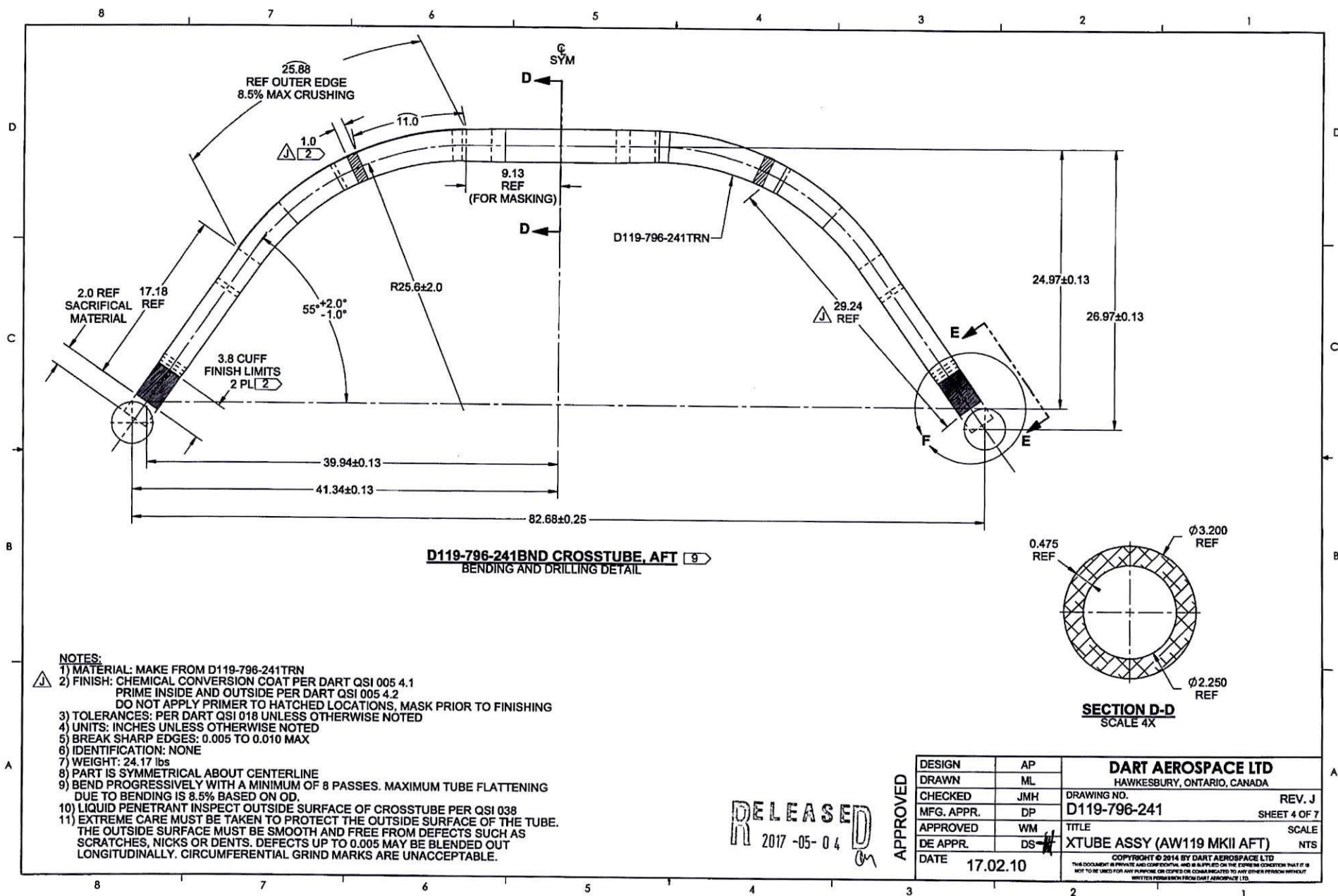
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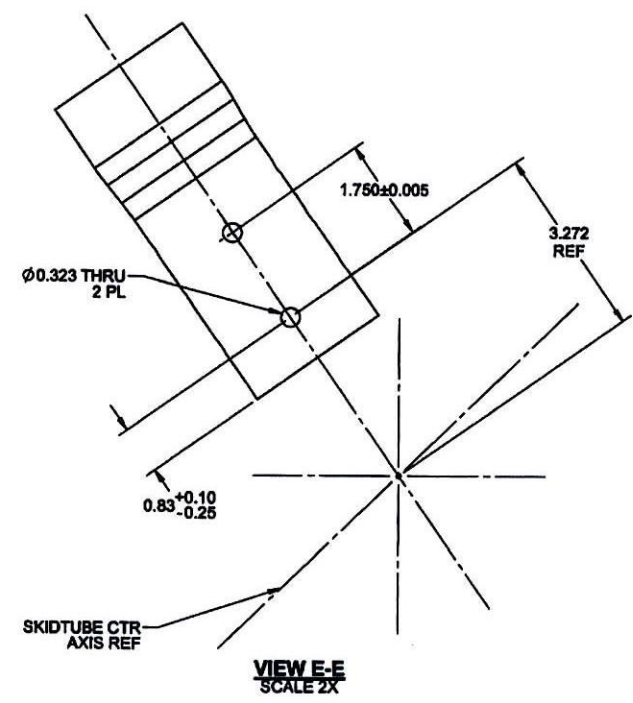
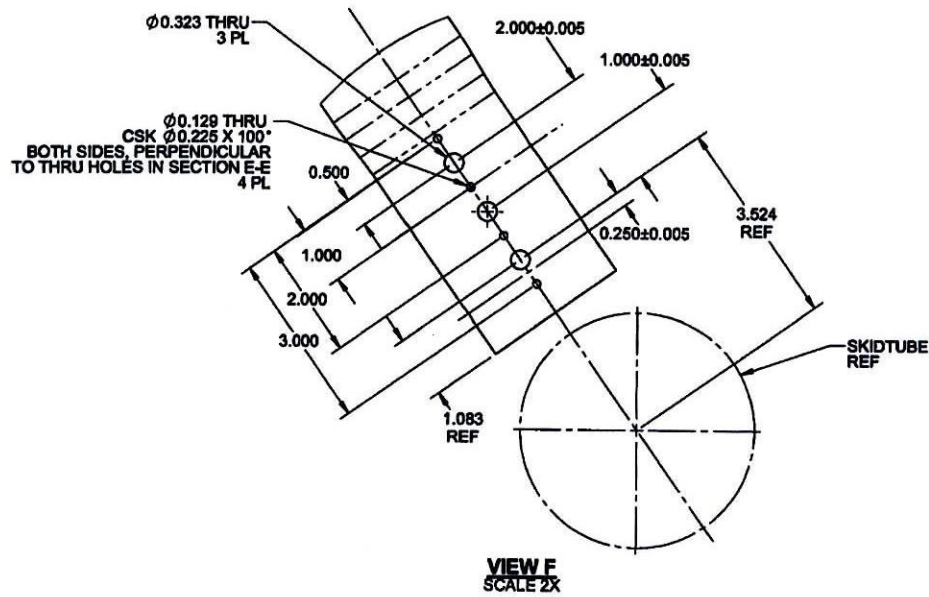


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MFG. APPR.	DP	D119-796-241	SHEET 3 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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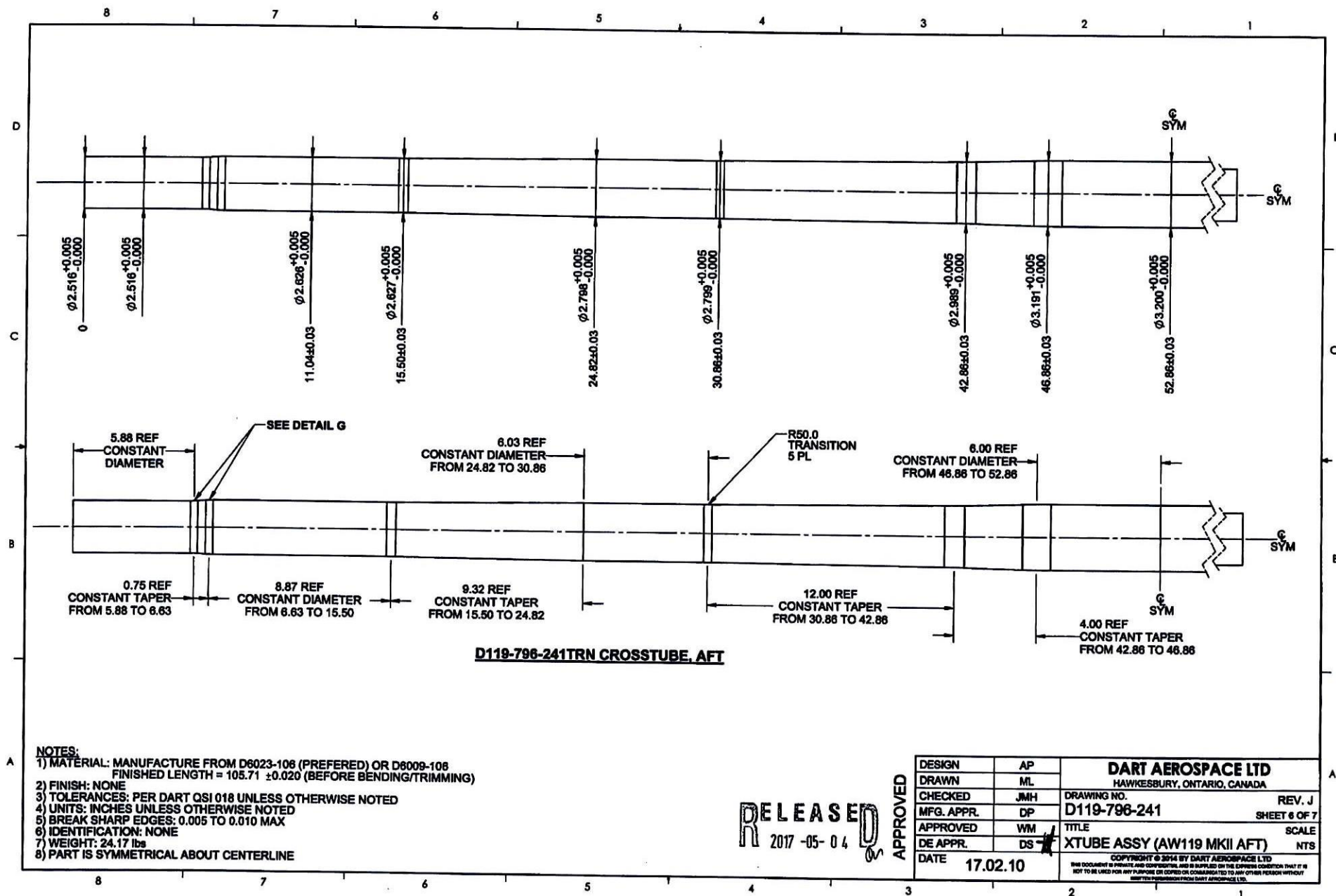


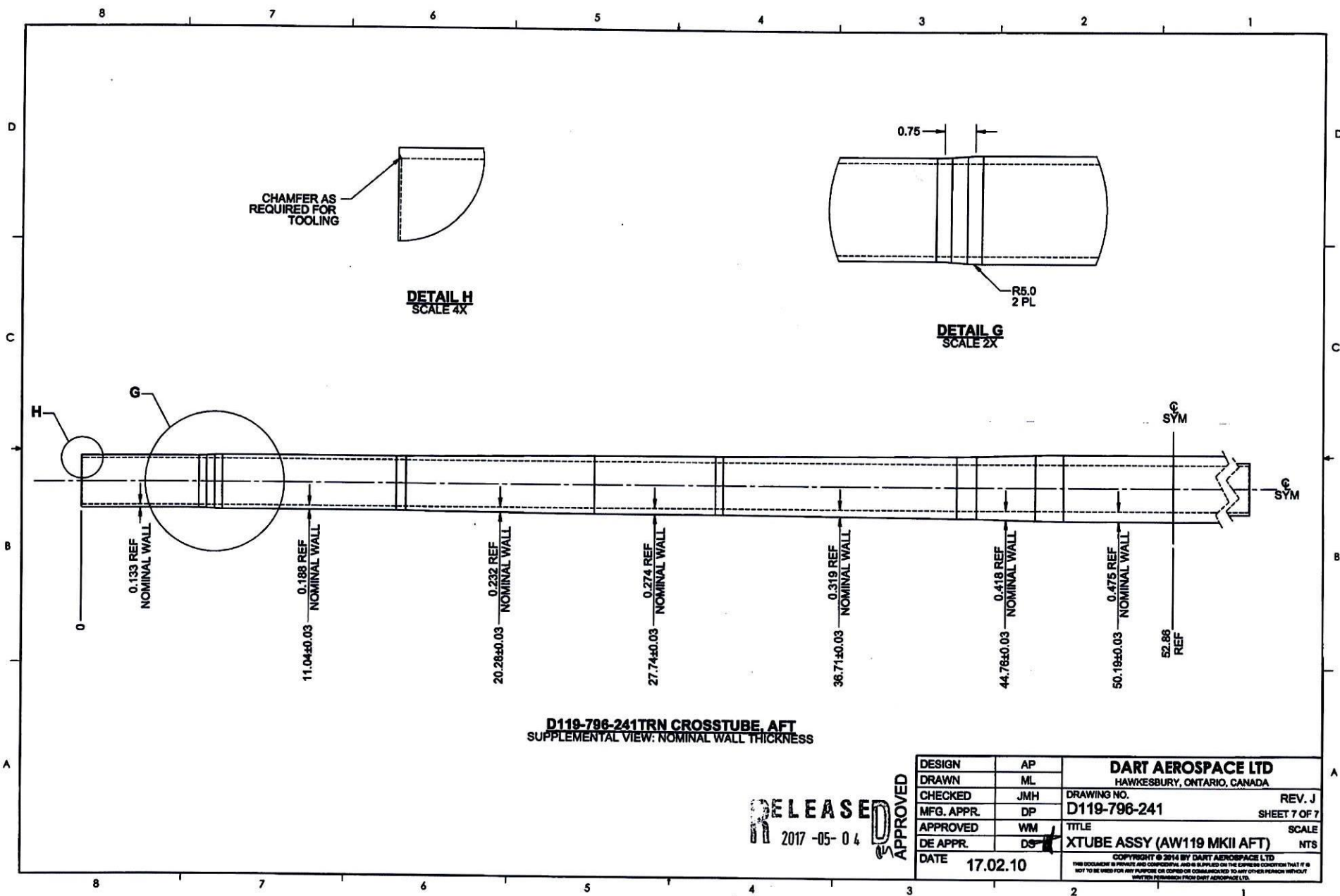


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2017-05-04

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MFG. APPR.	DP	D119-796-241	SHEET 5 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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2017-05-04

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 7 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CORRECTIVE AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040211

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO040211
PO Date: 6/15/18
Due Date: 6/18/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

JUN 29 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174947	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	174949			Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
	178857			Firmed	6/19/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
Sub Total:						3	0	3		\$626.25
2	178023	D212-664-207	Aft Crosstube - Low Standard *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	6/18/18	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
JUL 05 2018										Grand Total: \$835.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



skyservice

Work Order Traveler
Sky Service F.B.O. Inc.

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

Reference: PO040211

Qty: 1

WO #: MWO36389

Customer: Dart Aerospace Ltd.

Dept: NDT YUL

PN:

S/N:

Descr:

Model:

Reg:

A/C S/N:

Make:

CSN:

TSO:

Sequence: 1

TSN:

Task: **UNSCHEDULED**

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING FOUR (4) CROSSTUBES:

P/N: D119-796-241 Aft CROSSTUBE
1- JOB SHEET# 174947 2- JOB SHEET# 174949
3- JOB SHEET# 178857

P/N: D212-664-207 Aft CROSSTUBE
4- JOB SHEET# 178023

Action Taken:

LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-4) AS PER ASTM1417M-16

-CROSSTUBE P/N D212-664-207 JOB SHEET 178023, ONE FATIGUE CRACK FOUND ON SUSPECTED AREA ON CENTER LOWER AREA. NO CRACK FOUND ON REMAINING AREAS OF CROSSTUBE.

-NO CRACK FOUND ON THE 3 OTHER CROSSTUBES.

PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)

Date:

Initial/Stamp:

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:

CHRISTIAN BRIEN

ACA/SCA
Stamp



Date

15
20

**Sky Service F.B.O. Inc.**

10105 Ryan Avenue
Dorval, Quebec
H9P 1A2
Tel: 514-636-3300 Fax: 514-636-4855

Dart Aerospace Ltd.
Attention: Warran Boyd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Description: 4 CROSSTUBES

INVOICE

Invoice Number: MWQ37386

Invoice Date: Jun 28, 2018

WP: MWO36389

Terms: NET30

Customer PO: PO040211

Customer ID: DARAER1C

Department: NDT YUL

Tail No:

Type:

Serial No:

Description**Amount**

NDT MWO36389 4 CROSSTUBES	Labor:		835.00 CAD
	Flat Labor		835.00 CAD
	Sub-Total:		835.00 CAD
	HST ON:		108.55 CAD
	Total:		943.55 CAD

Electronic Funds Transfer (EFT) ACH / Wire Transfer Information:

HSBC Bank Canada
70 York Street
Toronto, Ontario
M5J 1S9
Bank#: 016
Transit No.: 10002
Account No.: 002657279001 (CDN Account)
Beneficiary: Sky Service F.B.O. Inc.
Swift Code: HKBCCATT
ABA#: 001610002

Remit to:
Sky Service F.B.O. Inc.
6120 Midfield Road
Mississauga, Ontario
Canada L5P 1B1

Thank you for your business

www.skyservice.com